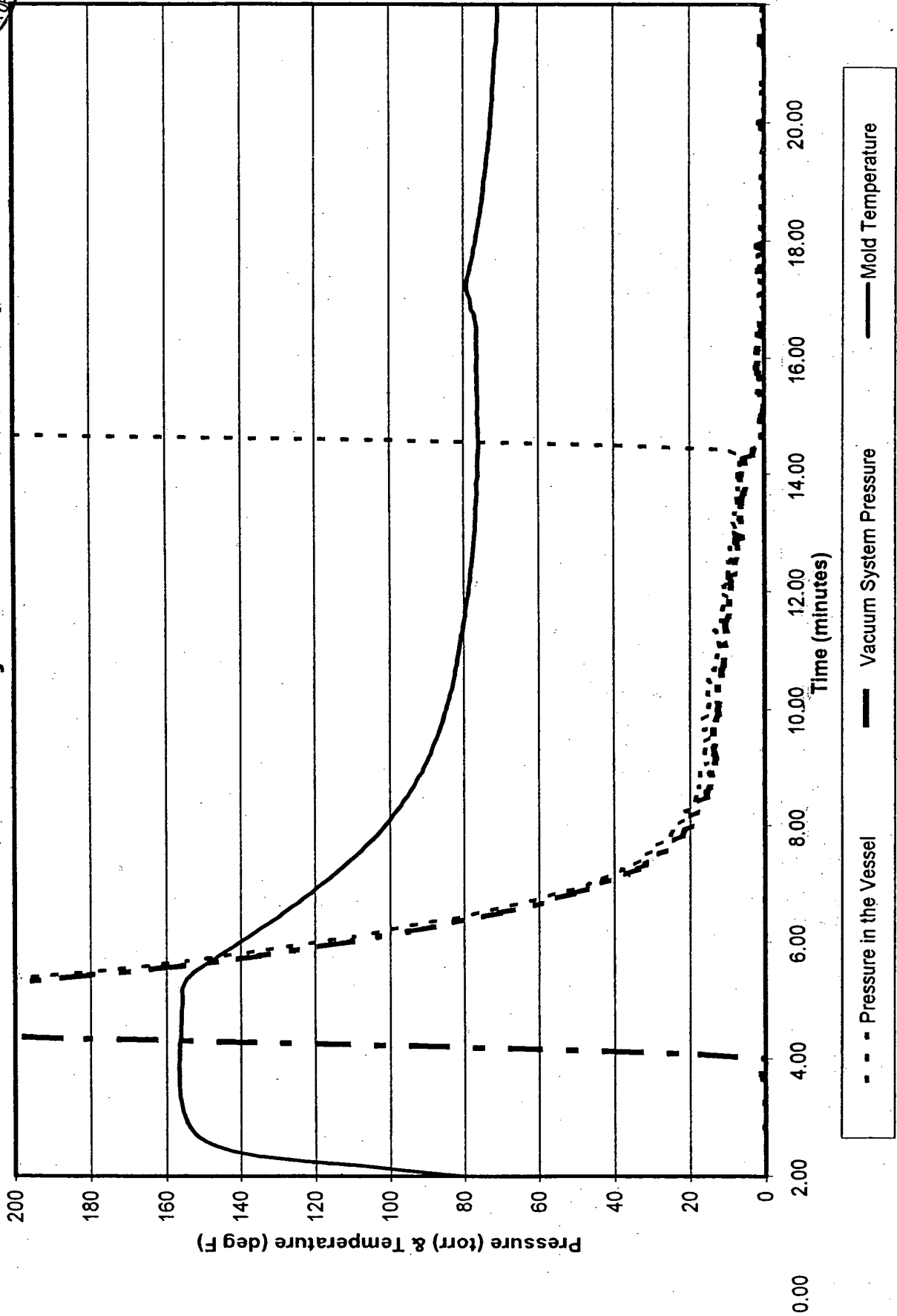


Sheet 1 of 7
Serial No. 10/781,397
Confirmation No.: 1881
Attorney Docket No.: 100P270US01
Attorney: Robin A. Sannes
Phone: 612-331-7419

FIG. 1
GMBOND Vacuum System - Pressure / Temperature

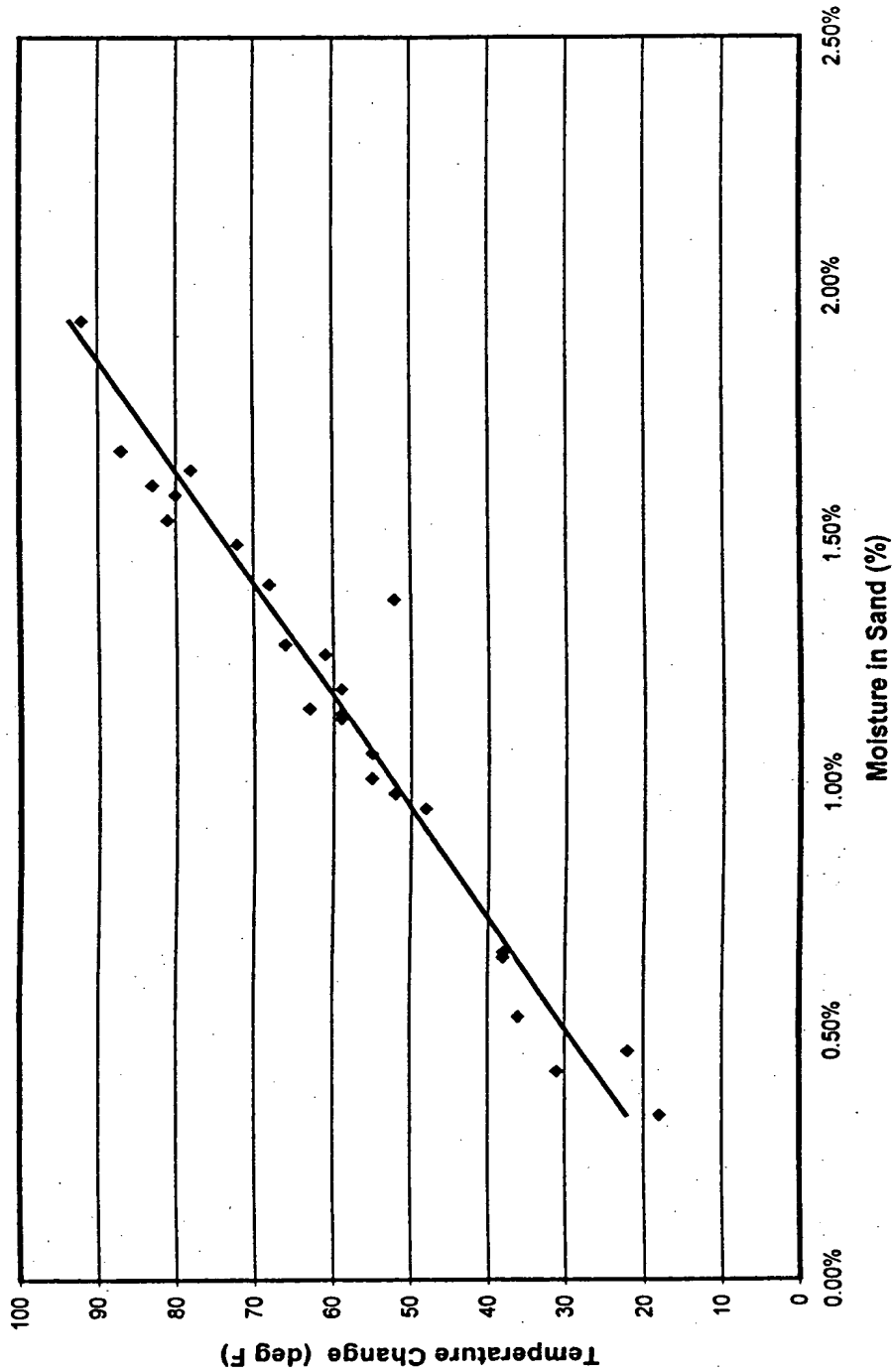


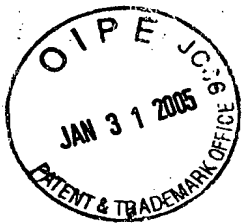


Sheet 2 of 7
Serial No. 10/781,397
Confirmation No.: 1881
Attorney Docket No.: 100P270US01
Attorney: Robin A. Sannes
Phone: 612-331-7419

FIG. 2

Temperature Change During Vacuum Drying

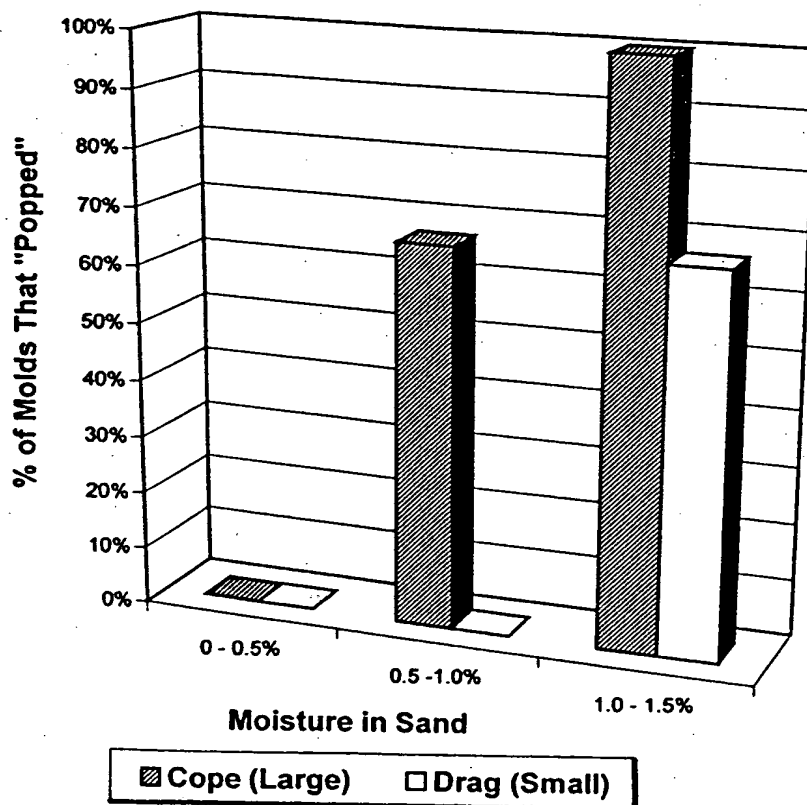




Sheet 3 of 7
Serial No. 10/781,397
Confirmation No.: 1881
Attorney Docket No.: 100P270US01
Attorney: Robin A. Sannes
Phone: 612-331-7419

FIG. 3

Mold Quality - "Popping" During Vacuum Drying

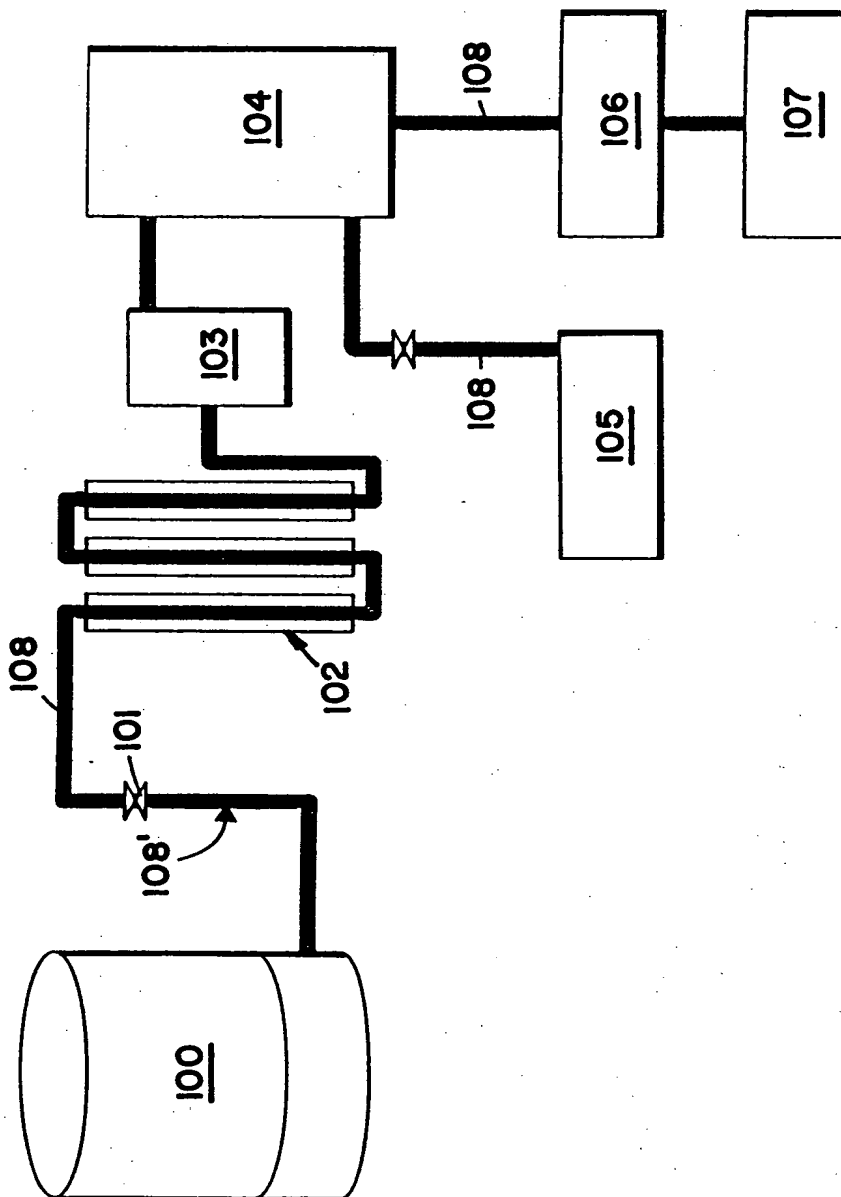




Sheet 4 of 7
Serial No. 10/781,397
Confirmation No.: 1881
Attorney Docket No.: 100P270US01
Attorney: Robin A. Sannes
Phone: 612-331-7419

Vacuum Chamber and Connections

FIG. 4



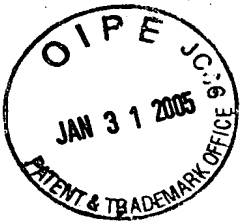


FIG. 5

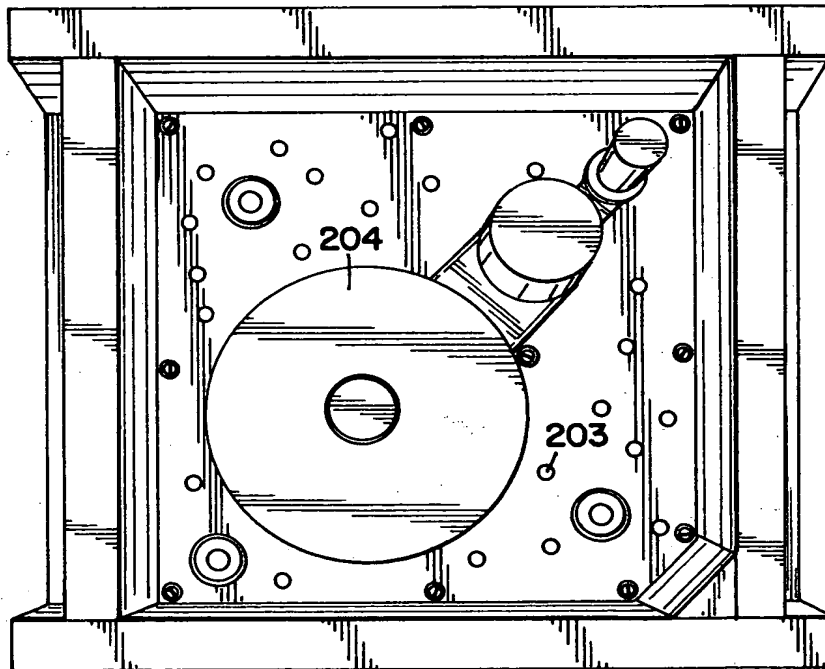
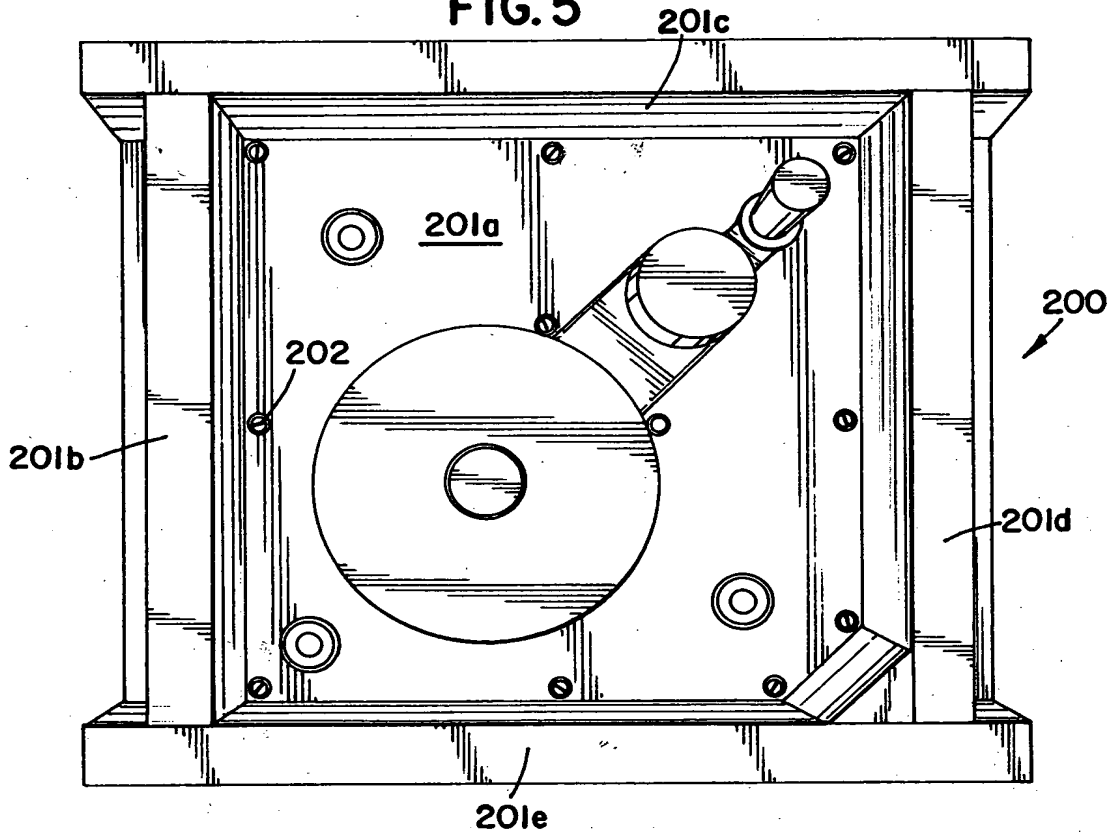


FIG. 6



Sheet 6 of 7
Serial No. 10/781,397
Confirmation No.: 1881
Attorney Docket No.: 100P270US01
Attorney: Robin A. Sannes
Phone: 612-331-7419

FIG. 7

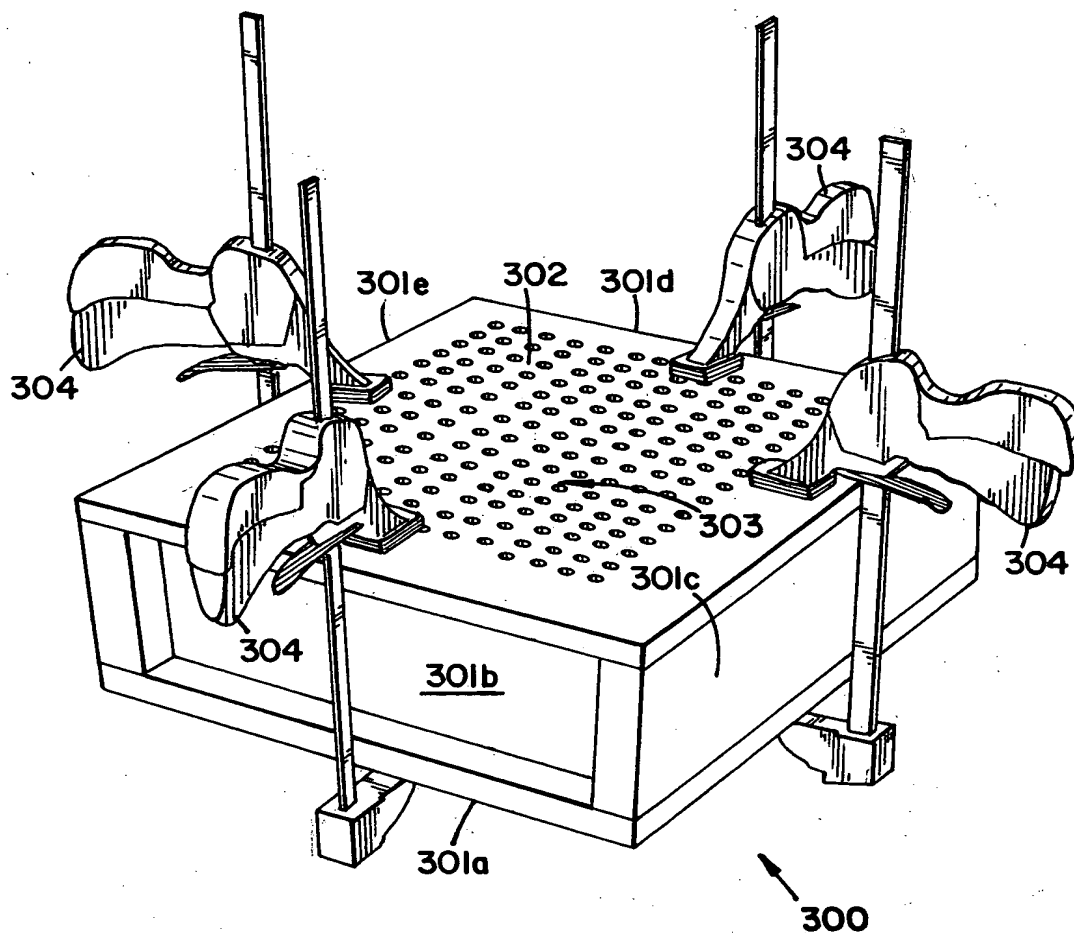




FIG. 8 **Moisture Effect on Scratch Hardness**
(Using Silica Sand Coated at Annex)

